

# Work Order ID 52901

October 19, 2009 12:34:45 PM

Page 1

Item ID: D3572-3

Accept

Revision ID: D

Item Name: Guide

Setup Start

Stop

Start Date: 10/19/09 Start Qty: 20.00

Required Date: 11/02/09 Req'd Qty: 20.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3572

Rev D

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank .500" long

OK 09/10/25

20 0

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1- Mill as per Folio FA685 Rev: C & Dwg D3572 Rev: D L12-Deburr

M.A 09/10/25

20 0

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

M.A 09/10/25

20 0

# Work Order ID 52901

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Item ID: D3572-3

Accept



Setup Start



Revision ID: D

Stop



Item Name: Guide

Start Date: 10/19/09 Start Qty: 20.00



Cust Item ID:

Required Date: 11/02/09 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130 QC8- Inspect parts - second check

0.00



QC Memo

0.00

Quality Control

*emb 04/10/26*

*20*

140 Identify as per dwg & Stock Location: *247*

0.00



Packaging Memo

0.00

Packaging

*09/14/27 (20)*

150 QC21- Final Inspection - Work Order Release

0.00



QC Memo

0.00

Quality Control

*09/11/02*

*MF 09-10-30*

# Picklist Print

October 19, 2009 12:34:54 PM

Page 1

Work Order ID: 52901

Parent Item: D3572-3RevD

Parent Item Name: Guide

Comments:

Start Date: 10/19/09

Required Date: 11/02/09

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B0.750X01.50 0		Purchased	No				f	17.2764	0.8004			



6061-T6 Bar .750 X 1.50

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

17.2764

110167

17.2764

.8004' on 10/10/24

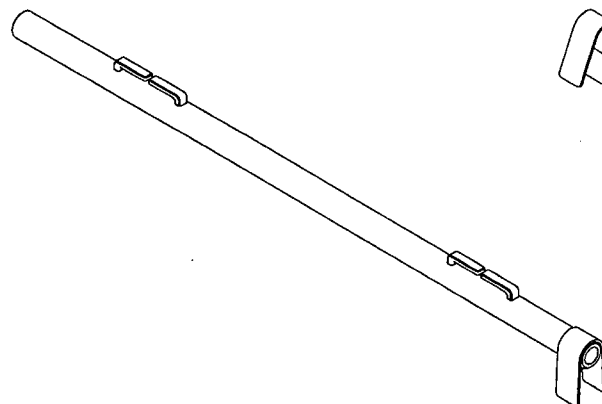


ITEM No.	QTY -041	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
1	X			D3572-041	GUIDE ASSEMBLY
2		X		D3572-043	GUIDE ASSEMBLY (UH-1)
3			X	D3572-044	GUIDE ASSEMBLY (UH-1) (OPP)
11	1	1	1	D3572-1	TUBE
12	4	4	4	D3572-3	GUIDE
13	1	3	3	D3572-5	BRACKET
14	-	-	-	D3572-7	DELETED AT REV C

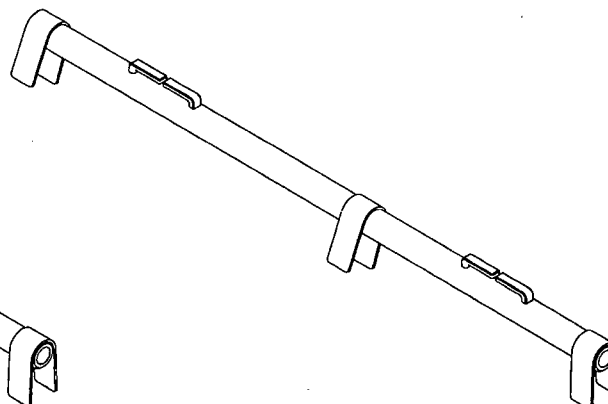
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*134 09-10-19*

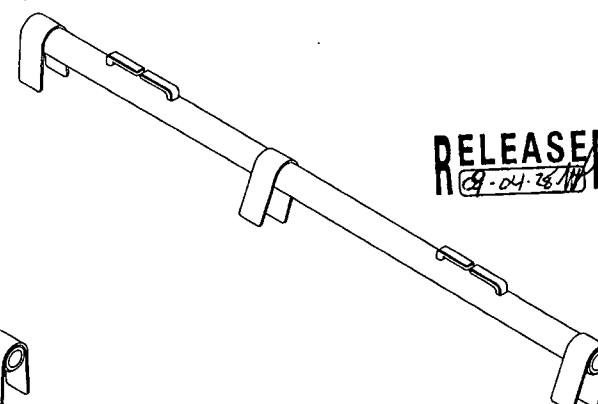
RELEASED  
*09-04-28/18*



**D3572-041 GUIDE ASSEMBLY**



**D3572-043 GUIDE ASSEMBLY (UH-1)**



**D3572-044 GUIDE ASSEMBLY (UH-1)**

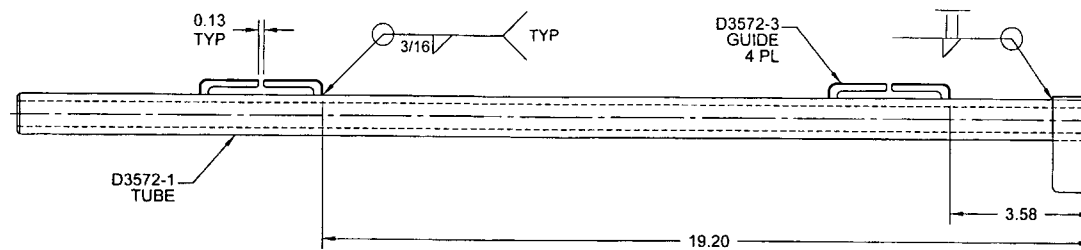
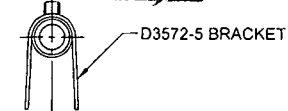
**NOTES:**

- 1) MATERIAL: NONE
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3572-XXX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -041: 1.34 lbs  
-043/-044: 1.42 lbs
- 8) WELDING: PER DART QSI 004

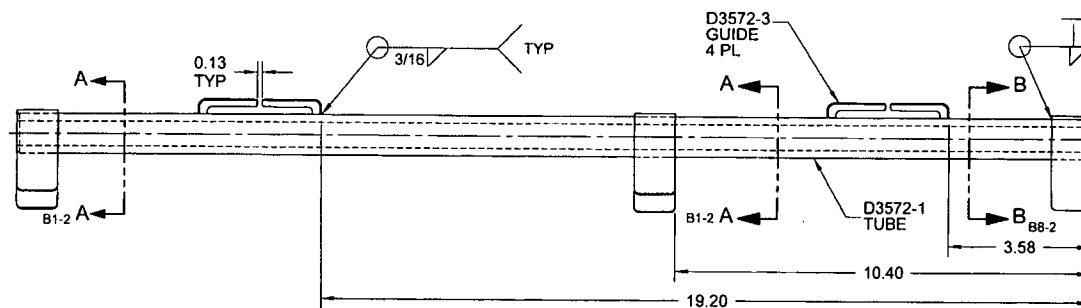
D	REDRAWN IN "B" SIZE FORMAT TO CURRENT STANDARDS. ADD -043, -044 FOR UH-1. SEE PAR 09-017.	AJS	09.04.17
C	REMOVE D3572-7	LE	07.06.01
B	FOR D3573-3 0.03 CHMF WAS 0.06; ADD TYP TO FILLET	LE	07.04.20
A	NEW ISSUE	LE	07.03.29
REV.	DESCRIPTION	BY	DATE
DESIGN	LE	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>[Signature]</i>	D3572	SHEET 1 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	GUIDE ASSEMBLY	NTS
DATE	09.04.17	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS NOT TO BE REPRODUCED OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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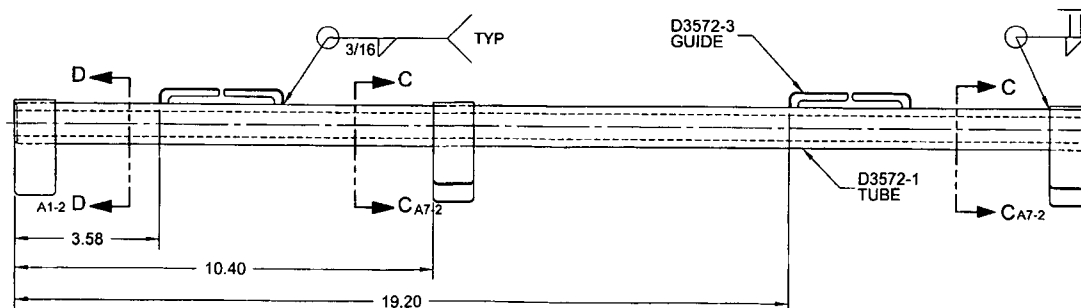
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**D3572-041 GUIDE ASSEMBLY**



**D3572-043 GUIDE ASSEMBLY**



**D3572-044 GUIDE ASSEMBLY**

**SECTION A-A** C7-2  
(2 PL)

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 09.04.17

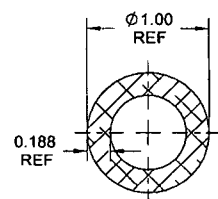
**SECTION D-D** A7-2

**SECTION B-B** C2-2

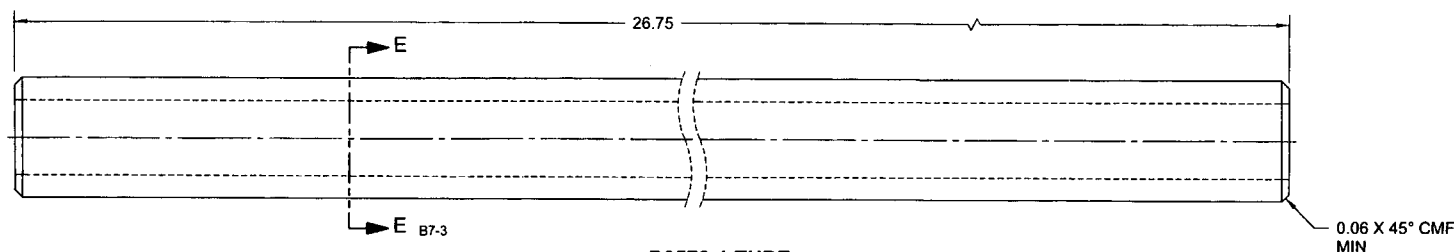
**SECTION C-C** A2-2  
A5-2

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**SECTION E-E** C5-3






**D3572-1 TUBE**

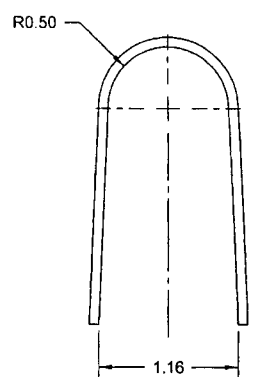
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**D3572-1 NOTES:**

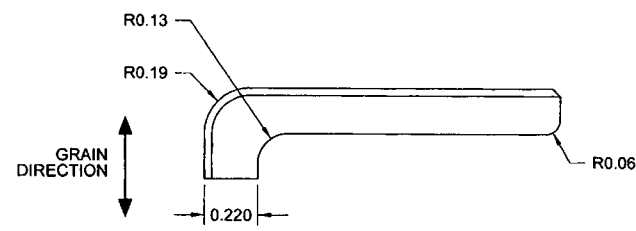
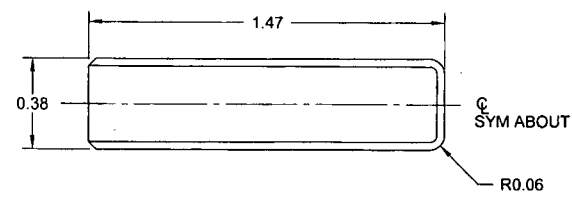
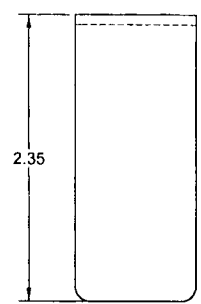
- 1) MATERIAL: 6061-T6 (T62) ALUMINUM TUBE 1.00 OD X 0.188 WALL  
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR AMS-QQ-A-200/8 OR AMS-QQ-A-225/8  
REF DART SPEC M6061T61.000W.188
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.25 lbs

DESIGN	LE	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
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CHECKED		DRAWING NO. <b>D3572</b>	REV. D
MFG. APPR.		TITLE	SHEET 3 OF 4
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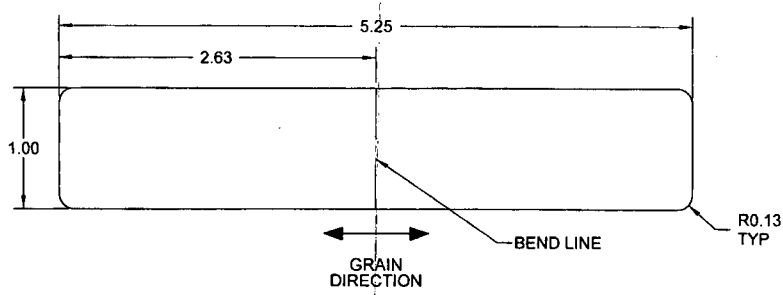
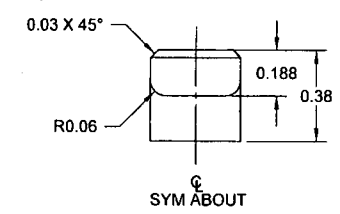
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**D3572-5 BRACKET**  
(MAKE FROM D3572-5F)



**D3572-3 GUIDE**



**D3572-5F FLAT PATTERN**

**RELEASED**  
9/04/13

- D3572-3 NOTES:**  
 1) MATERIAL: 6061-T6 (OR T651/T6510/T651/T62) ALUMINUM BAR  
 PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
 AMS-QQ-A-200/8 (OR AMS4160)  
 REF DART SPEC M6061T6B  
 2) FINISH: N/A  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
 6) IDENTIFICATION: N/A  
 7) WEIGHT: 0.01 lbs

- D3572-5 NOTES:**  
 1) MATERIAL: 6061-T6 (OR T62) ALUMINUM SHEET 0.080 THICK  
 PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
 REF DART SPEC M60601T6S.080  
 2) FINISH: N/A  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
 6) IDENTIFICATION: N/A  
 7) WEIGHT: 0.04 lbs

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